

Abstract

Page 1

[illegible]**Setup Start**

Stop

[illegible]

00000000000000000000

Cust Item ID:[illegible]

Customer:

Reference:

R

Date: 10/2-2 Tooling:

Date:

Run Start

RESEARCH DESIGN

QC:

Date:

SPC (Y/N):

Date:

Stop

Abstract

100	FLOW WATER JET	0.00	
Waterjet	Memo	0.00	B 10-12-20
FLOW CNC Waterjet	1-Cut as per Dwg D2143 <input type="checkbox"/> Dwg Rev: <u>C1</u> <input type="checkbox"/> Prog Rev: <u>C1</u> <input type="checkbox"/> 2-Debur if necessary		(40)
SS .040			
110	QC2- Inspect parts off machine FAI/FAIB	0.00	
QC	Memo	0.00	B 10-12-20
Quality Control			
120	QC8- Inspect parts - second check	0.00	
QC	Memo	0.00	contd (40)
Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 64308		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/12/20	# 130	Perm. change. Remove step # 130. Part Parts have no use for this operation at this step.	AD	11.01.06			S 10/12/20	

Part No: D2143 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64308

Thursday, December 02, 2010 8:56:15 AM

Page 3

Item ID:	D2143	Accept		Setup	Start	
Revision ID:						
Item Name:	Hinge Bracket				Stop	
Start Date:	12/2/2010	Start Qty: 30.00		Cust Item ID:		
Required Date:	12/9/2010	Req'd Qty: 30.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							40 BR 11-01-5.
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: 7:30 320° FINISH TIME: 8:00	0.00 0.00							40 BR 11-01-6.
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							40 M 11/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64308

Thursday, December 02, 2010 8:56:15 AM

Page 4

Item ID: D2143

Accept

Revision ID:

Item Name: Hinge Bracket

Start Date: 12/2/2010 Start Qty: 30.00

Required Date: 12/9/2010 Req'd Qty: 30.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 198

0.00

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/06 (40)11/01/06MF
11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 8:56:20 AM

Page 1

Work Order ID: 64308



Parent Item: D2143



Parent Item Name: Hinge Bracket

Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ C ☐ 00.05.18 ☐ Added inspection level 8 ☐ EC
IPP Rev:D Now on WaterJet 06-10-15 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	19.3234	0.066	2.084211	7.6		
5052-H32 .040 Sheet													

B10-12-20

Location

Loc Qty

Loc Code

MAT

16.3

114488

16.3

MAT23

3.0234

109058

1.6234

113123

1.4

39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

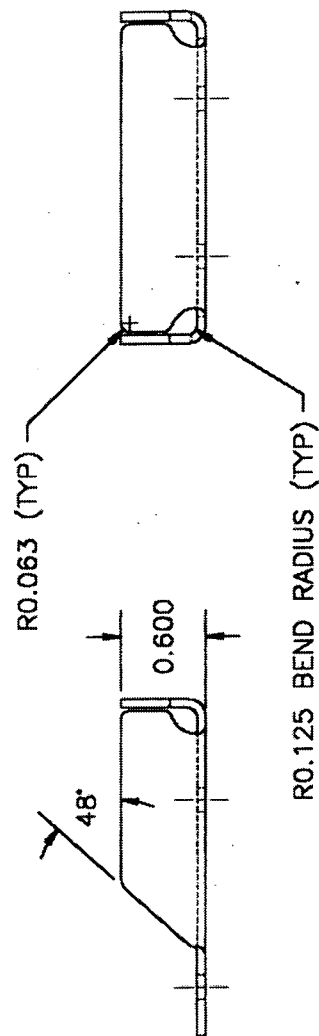
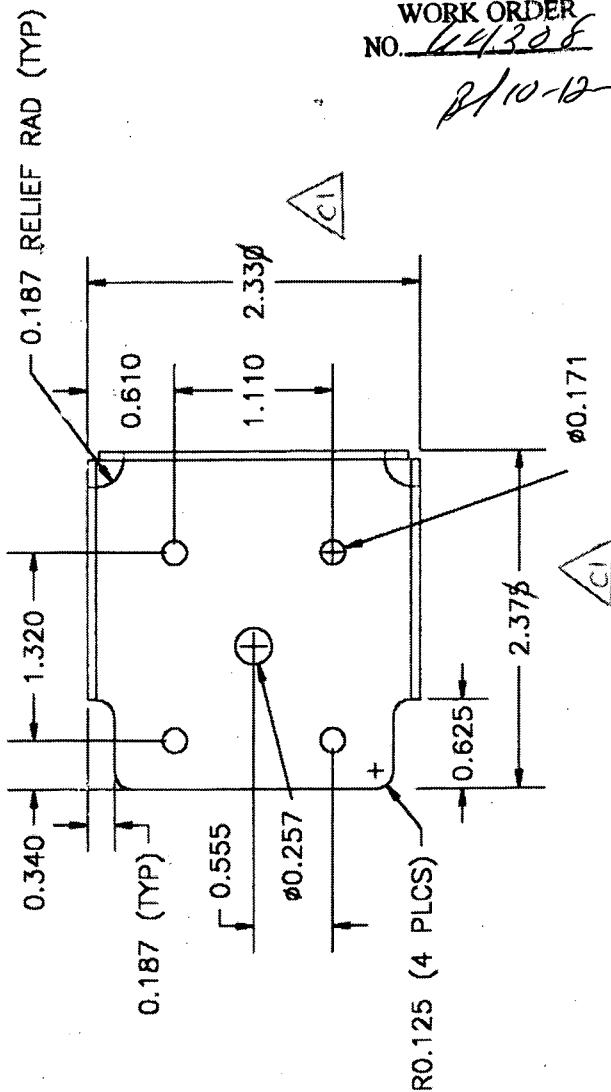


RELEASED
960620 Bw

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. C
CHECKED Bw	APPROVED Bw	D2143	SHEET 1 OF 2
DATE	TITLE		SCALE
92:07:10	HINGE BRACKET		
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
CI	4# 04.06.15	UPDATE DIMENSIONS	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64308

2/10-12-2



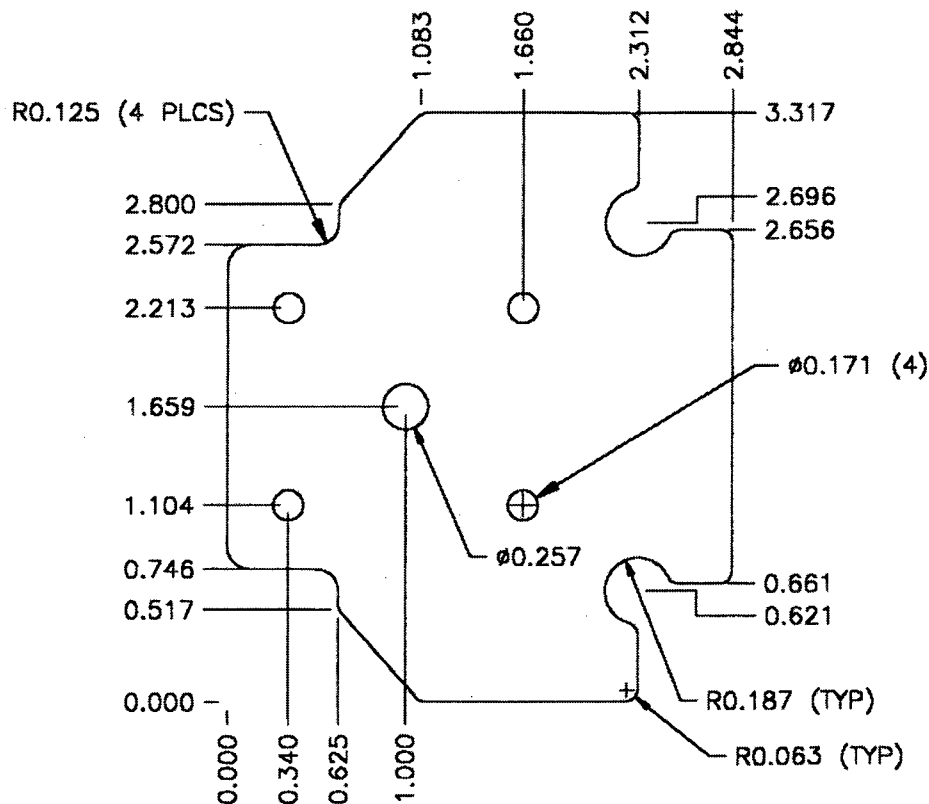
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. c
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:10:18	HINGE BRACKET FLAT PATTERN	1:1	

RELEASED
960620 62

u/o 44308



MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317